PART NO. DCAK027

(F) PROCESS - COPPER
O.D. - .373-.379 (9.47-9.62)
x .380 (9.7) MIN.
WALL - .028 (0.7) NOMINAL
PLUG, -3

▲ MUST USE ONLY AS

▲ 7.934-8.434
201.5-214.2

▲ 5.625-6.000
142.9-152.4

6.281-6.469
159.5-164.3

▲ 2.185-2.435
55.5-61.8

R 3.063-3.125
77.8-79.4

2.000-2.063
50.8-52.4

31°
35°

▲ 40°
50°

▲ 3.945-4.195
100.2-106.6

4.063-4.188
103.2-106.4

8.156-8.344
207.2-211.9

8.844-8.906
224.6-226.2

R

9.375 MAX.
238.1 MAX.

▲ 4.375-4.625
111.1-117.5

▲ 3.688-3.938
93.7-100.0

8.688-8.813
220.7-223.9

3.298-3.352
83.8-85.1

.969-1.094
24.6-27.8

A

B

C

D

E

(F) ▲ DISCHARGE - COPPER
O.D. - .375 (9.5) NOMINAL
END I.D. TO RADIUS - .253-.259 (6.43-6.58)
PLUG, -2
HAND FORM

▲ 2.563-2.813
65.1-71.5

▲ 1.396-1.646
35.5-41.8

E

▲ .219-.281
5.6-7.1

▲ 6.770-7.270
172.0-184.7

▲ SUCTION - LOCATION
NOT OPTIONAL, MUST
USE ONLY AS SUCTION

▲ SUCTION - COPPER
(F) O.D. - .500 (12.7) NOMINAL
WALL - .058 (1.5) NOMINAL
END I.D. - .378-.384 (9.60-9.75)
x .865 (22.0) MIN.
PLUG, -4

NOTE !

1. IF SPECIFIED ON BILL OF MATERIAL ASSEMBLE THESE PARTS AS SHOWN.

DIMENSIONING = INCHES / MILLIMETERS OR INCHES - (MILLIMETERS)

AK

Q.A. SYMBOLS
✱ = CATEGORY I
▲ = CATEGORY II
■ = CATEGORY III
= CATEGORY IV

MANUFACTURING NOTES !

1. SEE SPEC. "A-B" & "A-C" FOR PROCESSING.

A	32103-4		N.L.D. 9-11-96	HB 6/17/91	DATE
B	HA588-2		#234874 REVISED TUBE TOLERANCES	REDRAWN - NO CHANGE, ON TO CAD #220833	CHANGE
C	34525		8C 6F 3C	—	LT L.C.
D	34368-1		F	E	
E	34439				

PROPRIETARY INFORMATION
THIS DRAWING IS THE PROPERTY OF TECUMSEH PRODUCTS COMPANY (TECUMSEH) AND CONTAINS INFORMATION BELONGING TO TECUMSEH. ANY REPRODUCTION OR DISCLOSURE OF THE SPECIFIC CONFIGURATION THAT EITHER IT THEREIN OR DISCLOSED THEREIN SHALL BE DISCLOSED OR MADE AVAILABLE TO ANY THIRD PARTY WITHOUT THE EXPRESS WRITTEN CONSENT OF TECUMSEH IS PROHIBITED. THIS DRAWING IS ONLY AS EXPRESSLY AND SPECIFICALLY APPROVED IN WRITING BY TECUMSEH. ANY USE OF THIS DRAWING NOT SPECIFICALLY AUTHORIZED IN WRITING BY TECUMSEH'S PRIOR EXPRESS APPROVAL IS STRICTLY PROHIBITED. ANY REPRODUCTION OR DISCLOSURE OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON WITHOUT TECUMSEH'S PRIOR EXPRESS APPROVAL IN WRITING IS STRICTLY PROHIBITED. ANY USE OF THIS DRAWING NOT SPECIFICALLY AUTHORIZED IN WRITING BY TECUMSEH AT THE TIME OF REQUEST SHALL BE RETURNED TO TECUMSEH AT THE ADDRESS WHICH APPEARS HEREON.

DO NOT SCALE THIS DRAWING ALL FERROUS METAL PARTS ARE NOT TO BE PLATED UNLESS SPECIFICALLY REQUESTED BY CUSTOMER AT TIME OF QUOTATION OR AT TIME ORDER IS RECEIVED

DIS.CODE 340

NAME SALES COMPRESSOR

DWN.	CK.	APR.	SCALE
BRODERICK 6/17/91	McCAUGHEY 9-11-96	BLANDEN	1/2"=1"

THIS PRINT SUPERSEDES ALL PRINTS PRIOR TO

TECUMSEH PRODUCTS CO.
TECUMSEH, MICHIGAN

MATERIAL

INTERNAL USE ONLY
UGIIDISK5:[NDANIELS]AK-DCAK027□F-C.PRT

PART NO. DCAK027